

6061TGRT .375 WGS8

Work Order ID 148673

148673

Page 1

Wednesday, July 06, 2016 8:40:04 AM

Item ID: D3903-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Spacer

Start Date: 8/2/2016 Start Qty: 60.00

60

Cust Item ID:

Required Date: 8/5/2016 Req'd Qty: 60.00

60

Customer:

Reference:

Approvals:

Process Plan:

DAS

21

9-89

Date: JUL 08 2016

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3903	B

100

0.09

100

Hardinge

Hardinge CNC Lathe Small

Memo

0.20

1-TURN AS PER FOLIO FA813 & DWG D3903,

FOLIO REV: AADWG REV: B

2-DEBURR AS REQUIRED

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Quality Control

Memo

0.10

DAS

49

9-89

16/08/23

DAS

49

9-89

16/08/23

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Date :		Step #:		QTY Effective :			MRB (QS1042) Approval																		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																	
Root Cause		FAULT CATEGORY																							
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Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

NR1

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.20

Quality Control

79

0

DAS

20

9-89

16-08-23

125

0.00

125

Skidtubes

Memo

0.10

Skidtubes

Clean spacers with Ultra Aluminum Cleaner

Batch: N/A

79

0

BE 16-08-23

130

Identify as per dwg & Stock Location

0.00

130

Packaging

Memo

0.10

Packaging

LOCATION : LG001

79

0

BE 16-08-23

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
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Description Work Order Deviation		Disposition		Completed By	
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Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	QC21- Final Inspection - Work Order Release	0.00					21 21		
140							9-89		
QC	Memo	1.00							AUG 24 2016
Quality Control							em	16/08/23	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Picklist Print

Wednesday, July 06, 2016 8:40:04 AM

Page 1

Work Order ID: 148673

148673

Parent Item: D3903-1

D3903-1

Parent Item Name: Spacer

Start Date: 8/2/2016

Required Date: 8/5/2016

Start Qty: 60.00

Required Qty: 60.00

Comments: IPP RevA: New issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6T0.375W.058		Purchased	No			100	f	74.3770	0.345	21.78947			

M6061T6T0 375W 058

6061-T6 RD Tube .375 x.058W

Location

MAT013

m130510

m134993

Loc Qty

74.377

5.247

69.13

Loc Code

2476

DAS
49
9-89

16/08/23

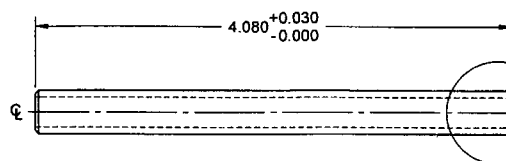
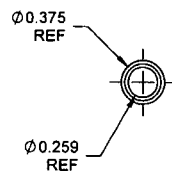
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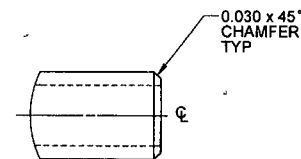
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Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER :							



B2-1
DETAIL A

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 148613 MJS
16-07-08



DETAIL A C3-1
SCALE 2X

D3903-1 SPACER

RELEASED
09/07/15

- NOTES:**
- 1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM SEAMLESS TUBING 0.375" OD x 0.058" WALL PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR QQ-A-200/8 OR QQ-A-225/8 OR ASTM B210 OR ASTM B241 (REF DART SPEC. M6061T0.313W.058)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.02 lbs

B	CORRECT TYPO Ø0.375 WAS Ø0.313 (ZN A6-1)	RF	09.06.30
A	NEW ISSUE	RF	09.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE USA, INC. PORT HADLOCK, WA DRAWING NO. D3903 REV. B SHEET 1 OF 1 TITLE SPACER SCALE NTS	
DRAWN	RF		
CHECKED	RF		
MFG. APPR.	RF		
APPROVED	RF		
DE APPR.	RF		
DATE	09.06.30		

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